

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40608
Estimate Number : 13433
P.O. Number :
This Issue : 24/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 17/07/2008 Type : LARGE FAB ASSY
Previous Run :
Written By :
Checked & Approved By : MF 08-07-24
Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : FWD ADJUSTABLE BLADE SUPPORT A
Part Number : PB674300115
Drawing Number : B6743001 P.7
Project Number : N/A
Drawing Revision : B1
Material :
Due Date : 24/07/2008 Qty: 2 U

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001257 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube

batch: 40585

2.0 PB6743001249 Inner Tube Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube Bushing

batch: m12141

3.0 PB6743001253 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340045

4.0 PB6743001254 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset

batch: 340053

5.0 PB674300171 PB67-43001-71



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-71

batch: 340027

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg		
7.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		
8.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
9.0	MS124780	HELICAL INSERT
Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) HELICAL INSERT		
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush in area of PB67-43001-249 only 2- tap drill for helicol 3- install helicol insert as per dwg		
11.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
13.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING 1- MASK TUBE FROM BASE TO GUSSET 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3		

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40 OF
 320
 2:10

M-H 08/07/31

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/31

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

20 Degree Cover Plate

batch: 40094

08-08-26

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-83

batch: 40096

W2S done for 2 only

08-08-26

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: 108986

see split.

08-08-26

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch: 108473

08-08-26

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

08-08-26

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

QC5



INSPECT WORK TO CURRENT STEP

Soslo/23 @



Comment: INSPECT WORK TO CURRENT STEP

21.0

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and *check*

Location:

card welding Soslo/23 @

22.0

QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-23

